

Date: Tuesday, 01/04/2008 3:47:58 PM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: DART 4-MAN 3-POINT AFT FACING SHOULDER HARNESS ASSEMBLY		
Job Number	: 38286		Part Number	: D412702045B		
Estimate Number	: 12867		Drawing Number	: IIN D412-702 REV E		
P.O. Number	:		Project Number	: N/A		
This Issue	: 01/04/2008		Drawing Revision	: E		
Prsht Rev.	: NC		Material	:		
First Issue	: / /		Due Date	: 08/04/2008		
Previous Run	: 38079		Qty:	4 Um: Each		
Written By	:					
Checked & Approved By	: <u>JD</u> 08-4-01					
Comment	: est rev A 07.05.10 new issue EC Est Rev:B 07-07-06 As per Rev E JLM					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	
		Comment: DOCUMENT CONTROL Photocopy bluefile & type labels per PPP D412-702-045B <u>CHG002</u>	<u>CHG003</u> <u>08/04/09</u> <u>08/14/14</u> <u>JLD</u>
2.0	D412702111B	HARNESS ASSEMBLY	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s) HARNESS ASSEMBLY <u>B38308</u>	<u>AS</u> <u>08/04/17</u> <u>x4</u>
3.0	D412702113B	HARNESS ASSEMBLY	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s) HARNESS ASSEMBLY <u>B38309</u>	<u>AS</u> <u>08/04/17</u> <u>x4</u>
4.0	D3572041	GUIDE ASSEMBLY	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s) GUIDE ASSEMBLY <u>B38300</u> <u>AS</u> <u>08/04/17</u> <u>x4</u>	<u>AS</u> <u>08/04/17</u> <u>x4</u>
5.0	AN416A	Bolt	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s) Bolt <u>M19278</u>	<u>AS</u> <u>08/04/17</u> <u>x4</u>

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 01/04/2008 3:47:58 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DART 4-MAN 3-POINT AFT FACING SHOULDER HARNESS  
ASSEMBLY

Job Number: 38286

Part Number: D412702045B

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0 AN425A BOLT



*AS* Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

BOLT

M104438

AS 08/04/17 (X4)

7.0 AN960JD416 Washer



*AS* Comment: Qty.: 20.0000 Each(s)/Unit Total : 80.0000 Each(s)

Washer

batch:

M107321

AS 08/04/17 (X4)

8.0 MS21042L4 Nut



*AS* Comment: Qty.: 6.0000 Each(s)/Unit Total : 24.0000 Each(s)

Nut

batch:

M106825

AS 08/04/17 (X4)

9.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



*AS* Comment: INSPECT 100% KITS FOR COMPLETENESS

10.0 PACKAGING 1 PACKAGING RESOURCE #1



*AS* Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-702-045B CHG001

Location:

PPP Rev:

Rev C

AS 08/04/20 (X4)

11.0 QC21 FINAL INSPECTION/W/O RELEASE



*AS* Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



AS 08/04/30 (X4)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041B	QTY -043B	QTY -045B	QTY -047B	QTY -049B	Part Number	Description
X					D412-702-041B	Dart 13-Man 3-Point Shoulder Harness Kit
	X				D412-702-043B	Dart 5-Man 3-Point Forward Facing Shoulder Harness Kit
		X			D412-702-045B	Dart 4-Man 3-Point Aft Facing Shoulder Harness Kit
			X		D412-702-047B	Dart 4-Man 3-Point Side Facing Shoulder Harness Kit
				X	D412-702-049B	Dart 1-Man 3-Point Forward Shoulder Harness Kit
1	1		1	1	D412-702-059	GROMMET KIT
2	1		1		D412-702-101B	HARNESS ASSEMBLY
1*	1*		1*		D3573-7	ADAPTER
1*	1*		1*		D3579-046	SHOULDER HARNESS
1*	1*		1*		K6.2	CLIP
4*	4*		4*		MS24693S272	SCREW
4*	4*		4*		AN960JD10LL	WASHER
4*	4*		4*		MS21042L3	NUT
2	1		1		D412-702-103B	HARNESS ASSEMBLY
1*	1*		1*		D3573-8	ADAPTER
1*	1*		1*		D3579-045	SHOULDER HARNESS
1*	1*		1*		K6.2	CLIP
4*	4*		4*		MS24693S272	SCREW
4*	4*		4*		AN960JD10LL	WASHER
4*	4*		4*		MS21042L3	NUT
1	1			1	D412-702-105B	HARNESS ASSEMBLY
1*	1*			1*	D3573-1	ADAPTER
1*	1*			1*	D3579-046	SHOULDER HARNESS
1*	1*			1*	K6.2	CLIP
4*	4*			4*	MS24693S273	SCREW
4*	4*			4*	AN960JD10LL	WASHER
4*	4*			4*	MS21042L3	NUT
1	1				D412-702-107B	HARNESS ASSEMBLY
1*	1*				D3573-3	ADAPTER
1*	1*				D3579-046	SHOULDER HARNESS
1*	1*				K6.2	CLIP
4*	4*				MS24693S272	SCREW
4*	4*				AN960JD10LL	WASHER
4*	4*				MS21042L3	NUT
1	1				D412-702-109B	HARNESS ASSEMBLY
1*	1*				D3573-3	ADAPTER
1*	1*				D3579-045	SHOULDER HARNESS
1*	1*				K6.2	CLIP
4*	4*				MS24693S272	SCREW
4*	4*				AN960JD10LL	WASHER
4*	4*				MS21042L3	NUT

\*DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE

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Revision: E  
Date: 07.06.27

QTY -041B	QTY -043B	QTY -045B	QTY -047B	QTY -049B	Part Number	Description
2		2			D412-702-111B	HARNESS ASSEMBLY
1*		1*			D3570-1	BRACKET
1*		1*			D3579-047	SHOULDER HARNESS
4*		4*			MS24694S50	SCREW
4*		4*			AN960JD10L	WASHER
4*		4*			MS21042L3	NUT
2		2			D412-702-113B	HARNESS ASSEMBLY
1*		1*			D3570-2	BRACKET
1*		1*			D3579-048	SHOULDER HARNESS
4*		4*			MS24694S50	SCREW
4*		4*			AN960JD10L	WASHER
4*		4*			MS21042L3	NUT
1			1		D412-702-115B	HARNESS ASSEMBLY
1*			1*		D3573-5	ADAPTER
1*			1*		D3579-046	SHOULDER HARNESS
1*			1*		K6.2	CLIP
4*			4*		MS24693S272	SCREW
4*			4*		AN960JD10LL	WASHER
4*			4*		MS21042L3	NUT
1			1		D412-702-117B	HARNESS ASSEMBLY
1*			1*		D3573-5	ADAPTER
1*			1*		D3579-045	SHOULDER HARNESS
1*			1*		K6.2	CLIP
4*			4*		MS24693S272	SCREW
4*			4*		AN960JD10LL	WASHER
4*			4*		MS21042L3	NUT
2	2				D3542-1	BRACKET
7	3		4	1	D3571-1	GUIDE
2	2				D3571-3	GUIDE
2		2			D3572-041	GUIDE ASSEMBLY
12	6		6	2	D3578-041	DOUBLER
2	2				D3610-041	BRACKET
2	2				D3618-1	CAP
4	4				AN4-10A	BOLT
2		2			AN4-16A	BOLT
4		4			AN4-25A	BOLT
2	2				AN4-44A	BOLT
2	2				MS24693S274	SCREW
3	3			1	MS24694S56	SCREW
10	2		8		MS24694S58	SCREW
1	1			1	MS24694S60	SCREW
26	6	20			AN960JD416	WASHER
4	4				AN960JD416L	WASHER
12	6	6			MS21042L4	NUT
24	12		12	4	CR3212-4-4	RIVET

\*DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE

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